

Date: Thursday, 18/09/2008 11:14:01 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	FLANGE ASS'Y
<b>Job Number</b> :	42114		
<b>Estimate Number</b> :	13032		
<b>P.O. Number</b> :		<b>Part Number</b> :	D3651043
<b>This Issue</b> :	18/09/2008	<b>Drawing Number</b> :	D3651 REV.B
<b>Pre/lt Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	/ /	<b>Drawing Revision</b> :	B
<b>Previous Run</b> :	40856	<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	25/09/2008
<b>Checked &amp; Approved By</b> :	<u>NO 08.9.18</u>	<b>Qty:</b>	2
<b>Comment</b> :	Um: Each		
	: Est Rev:A New Issue 07-09-27 DD verified by: EC		
	: Est Rev:B ECN 1113P 08-01-22 DD		
	: Est Rev:C ecn1162 08-04-02 DD verified by: EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S26GA	304/316 0.018 SHEET
-----	-----------	---------------------



**Comment:** Qty.: 0.2573 sf(s)/Unit Total : 0.5145 sf(s)  
 304/316 SS sheet 26 ga (0.018" thick)

Batch: 108415 1B 8-9-22

(FOR D3651-7)

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------

**Comment:** FLOW WATER JET

1-Cut as per Dwg D3651 (D3651-7)

Dwg Rev: BProg Rev: B1B 8-9-22

2-Deburr if necessary  
 IDENTIFY AS D3651-7

1B 8-9-22

(4)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

1B 8-9-22**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

5 08/09/22 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

User:

Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLANGE ASS'Y

Job Number: 42114

Part Number: D3651043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

M304S26GA

304/316 0.018 SHEET



Comment: Qty.: 0.2573 sf(s)/Unit Total : 0.5145 sf(s)

304/316 SS sheet 26 ga (0.018" thick)

Batch: 108415 IB 8-9-22

(FOR D3651-5)

6.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3651 (D3651-5)

Dwg Rev: B IB 8-9-22

Prog Rev: B

2-Deburr if necessary

Identify as D3651-5

IB 8-9-22

(4)

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-9-22

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

S 08/09/24 (4)

9.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form D3651-5 and D3651-7 as per Dwg D3651

SB 08/09/24

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/24 (4)

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3651

A 08/11/24 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 18/09/2008 11:14:01 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLANGE ASSY

Job Number: 42114

Part Number: D3651043

Job Number:



Seq. #: Machine Or Operation: Description :

12.0

QC9

VISUAL WELDING INSPECTION



(x4)

Comment: VISUAL WELDING INSPECTION

*Cpl 08-11-25*

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*1042-01*

14.0

D36513

Base



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

BASE

*44941*

*FF 09/02/05*

(4)

15.0

MS20427M33

Rivet



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Rivet

*M110022*

*64*

*FF 29/02/05*

(4)

16.0

MS210603K

Nut Plate



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut Plate

*M109590*

*32*

*FF 09/02/05*

(4)

17.0

CR3523401

RIVET



*(P70)*

Comment: Qty.: 57.0000 Each(s)/Unit Total : 114.0000 Each(s)

RIVET

*109371*

*FF 09/02/05*

(4)

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3651

*FF 09/02/05*

(4)

19.0

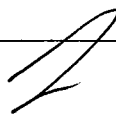

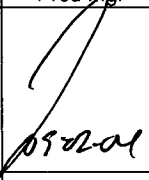
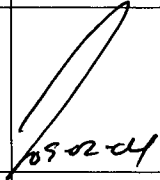
QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 09/02/05 (x4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09-02-04	17	Dwg calls up -2 rivet per m change 		09/02/25 (ALREADY DONE)			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 18/09/2008 11:14:01 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLANGE ASS'Y

Job Number: 42114

Part Number: D3651043

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: \_\_\_\_\_

*18/09/25 (9)*

21.0

QC21

FINAL INSPECTION/W/O RELEASE



*09/02/25*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*18/09/25*

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 42114
<b>Description:</b> FLANGE ASSY	<b>Part Number:</b> D3651-5
<b>Inspection Dwg:</b> D3651-5, Rev: B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.100	X			
Ø .129	+ .005 - .001	.132	X			
14.94	+/- .030	14.94	X			
.26	+/- .030	.262	X			
.500	+/- .010	.502	X			
.450	+/- .010	.452	X			
2.21	+/- .030	2.212	X			
.36	+/- .030	.355	X			
1.66	+/- .030	1.655	X			
.33	+/- .030	.330	X			
3.16	+/- .030	3.155	X			
.33	+/- .030	.331	X			
.98	+/- .030	.982	X			
.48	+/- .030	.481	X			
.25	+/- .030	.253	X			
<del>.19</del>	<del>+/- .030</del>					
.500	+/- .010	.499	X			
.19	+/- .030	.190	X			

<b>Measured by:</b> WB
<b>Date:</b> 8-9-22

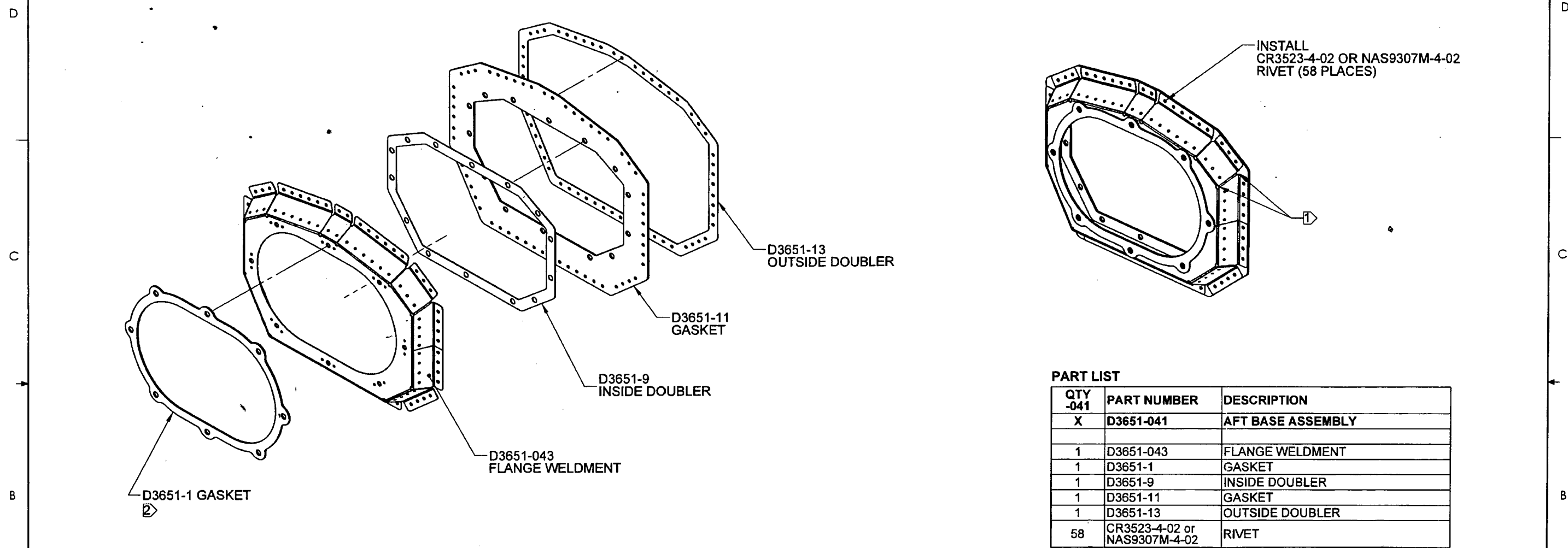
<b>Audited by:</b> S
<b>Date:</b> 08/09/22

<b>Prototype Approval:</b> n
<b>Date:</b> 1/17

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



8 7 6 5 4 3 2 1



**D3651-041 AFT BASE ASSEMBLY**

**PART LIST**

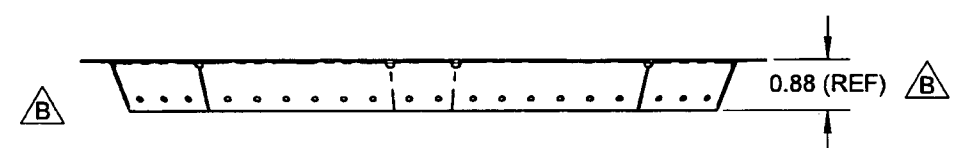
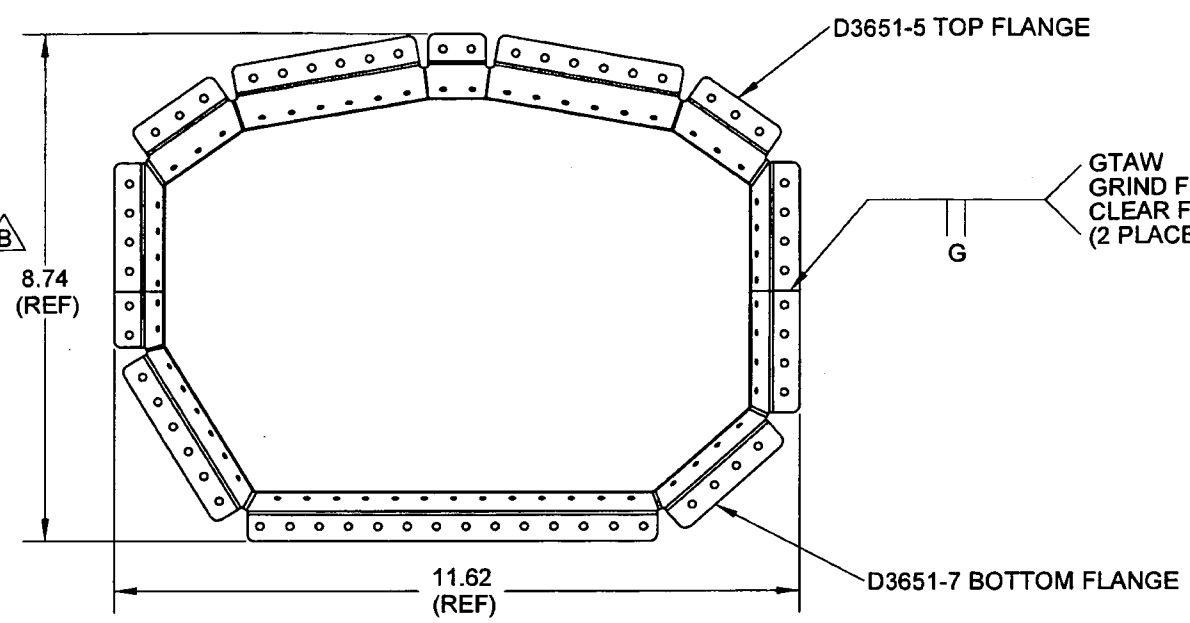
QTY	PART NUMBER	DESCRIPTION
X	D3651-041	AFT BASE ASSEMBLY
1	D3651-043	FLANGE WELDMENT
1	D3651-1	GASKET
1	D3651-9	INSIDE DOUBLER
1	D3651-11	GASKET
1	D3651-13	OUTSIDE DOUBLER
58	CR3523-4-02 or NAS9307M-4-02	RIVET

RELEASED  
03.27.08

- D3651-041 NOTES:**
- 1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT
  - 2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 1.6 lbs

B	SHEET 1: GENERAL UPDATE SHEET 2: 8.74 WAS 8.50; 0.88 WAS 0.98; REMOVED ANGLE SHEETS 4, 5, 6, 8 & 9: GENERAL DIMENSIONAL UPDATE SHEET 7: 5.514 WAS 5.504	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3651	SHEET 1 OF 9
APPROVED	RF	TITLE	SCALE
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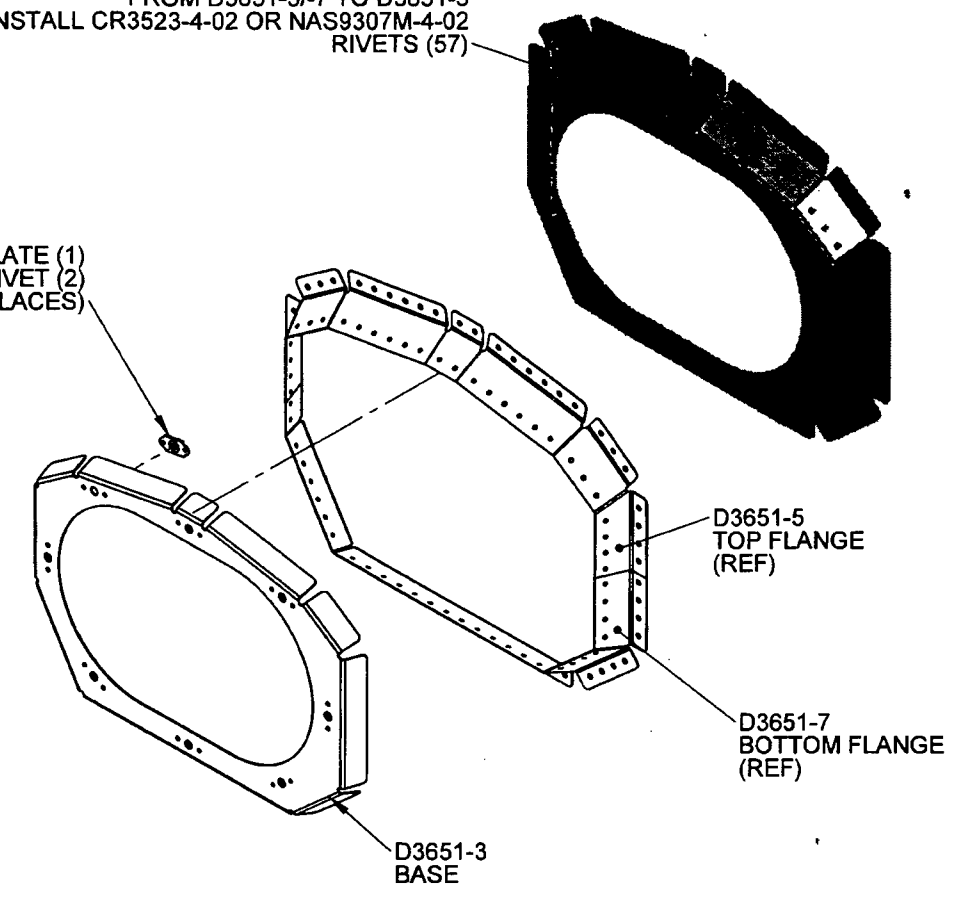


**D3651-043 FLANGE WELDMENT**

- D3651-043 NOTES:**
- 1) WELD PER QSI 004
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.76 lbs

TRANSFER DRILL  $\phi 0.129$  (#30 DRILL)  
FROM D3651-5/-7 TO D3651-3  
INSTALL CR3523-4-02 OR NAS9307M-4-02  
RIVETS (57)

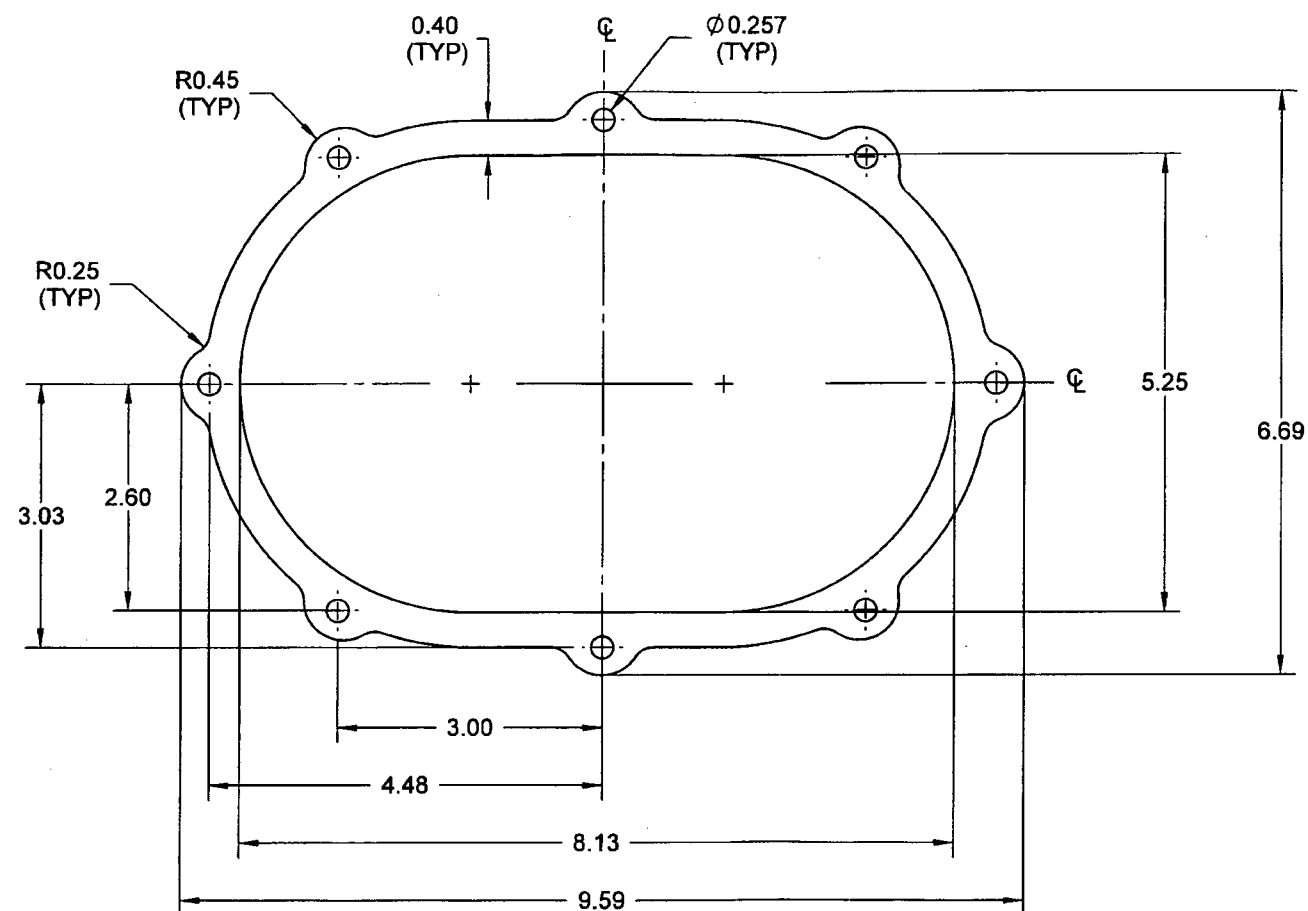
MS21060-3K NUTPLATE (1)  
MS20427M3-3 RIVET (2)  
(8 PLACES)



QTY -043	PART NUMBER	DESCRIPTION
X	D3651-043	FLANGE WELDMENT
1	D3651-3	BASE
1	D3651-5	TOP FLANGE
1	D3651-7	BOTTOM FLANGE
16	MS20427M3-3	RIVET
8	MS21060-3K	NUTPLATE
57	CR3523-4-02 or NA9307M-4-02	RIVET

RELEASED  
08-03-27-14

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		SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 42114		



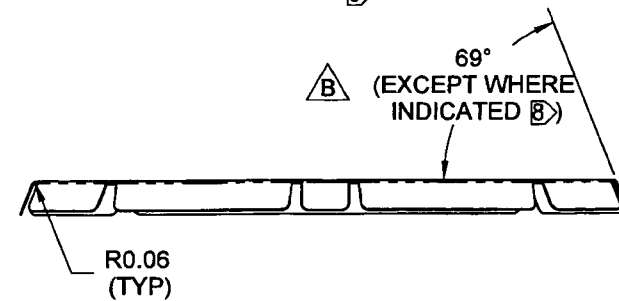
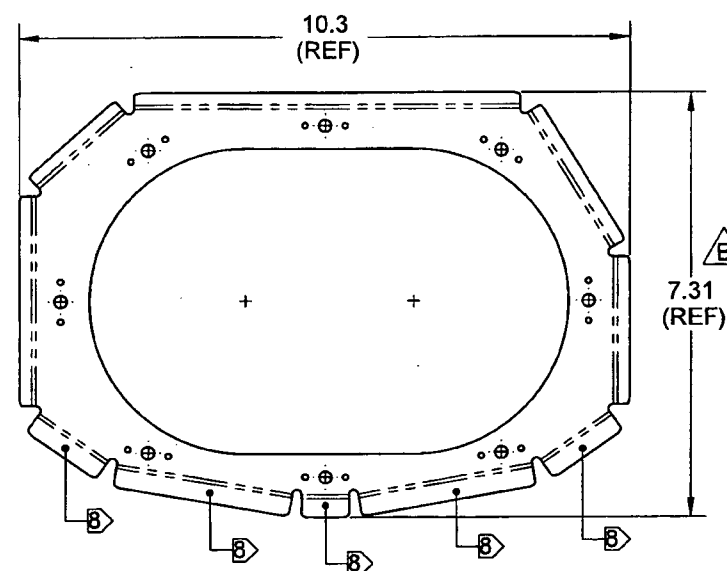
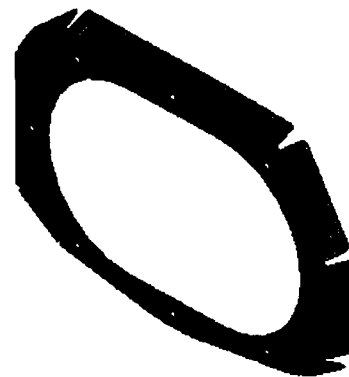
**D3651-1 GASKET**

**NOTES:**

- 1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)  
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) PART IS SYMMETRIC ABOUT  $\phi$
- 8) WEIGHT: 0.09 lbs

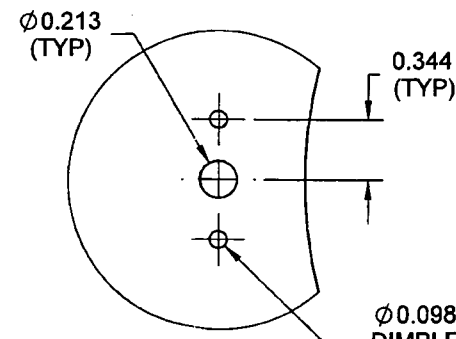
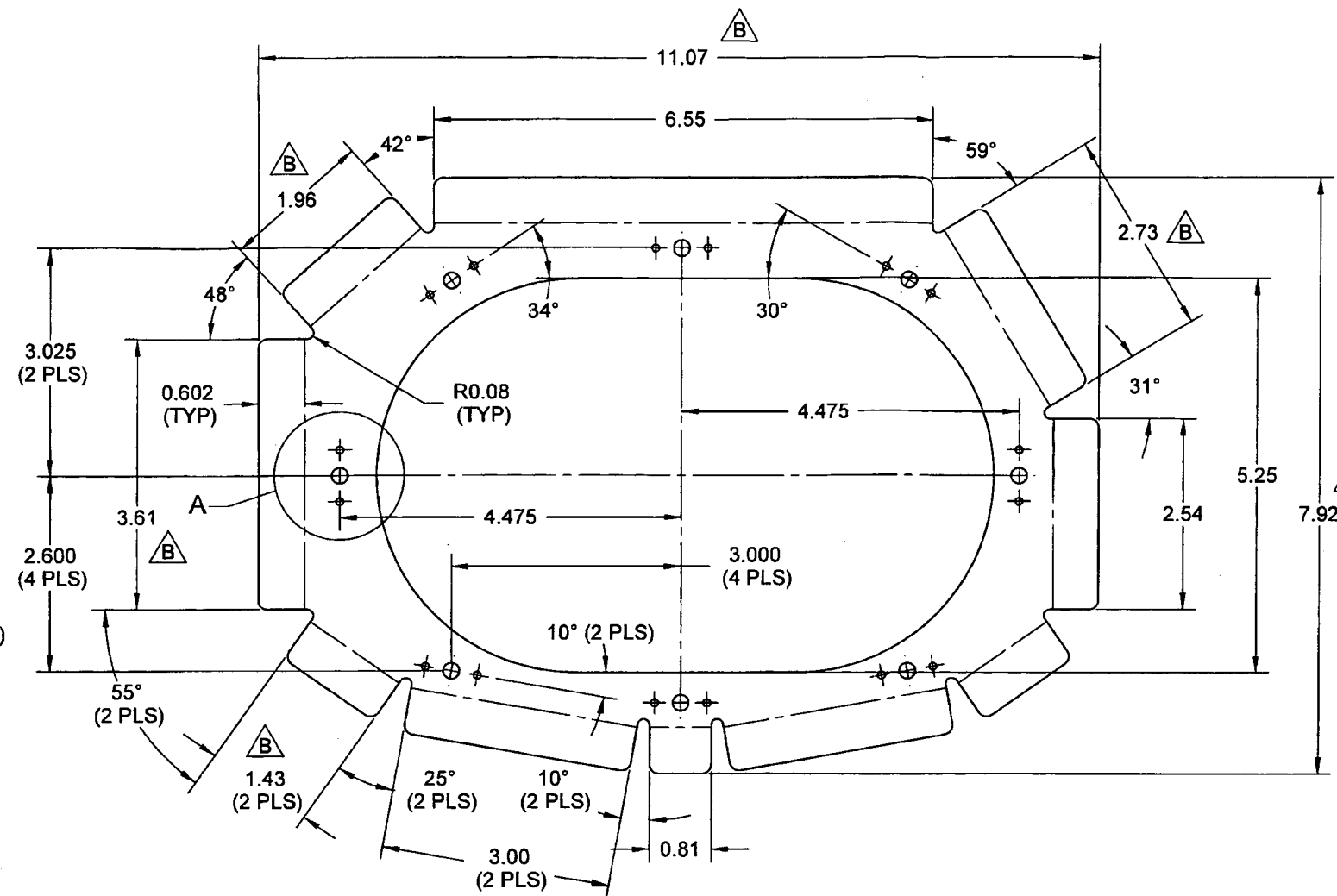
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CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3651</b>
MFG. APPR.	<i>[Signature]</i>	REV. B
APPROVED	<i>[Signature]</i>	SHEET 3 OF 9
DE APPR.	<i>[Signature]</i>	TITLE <b>AFT BASE ASSEMBLY</b>
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NO. **4214**



**D3651-3 BASE**  
(MAKE FROM D3651-3F FLAT PATTERN)

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.27 lbs
  - 8) BEND TO 55° WHERE INDICATED

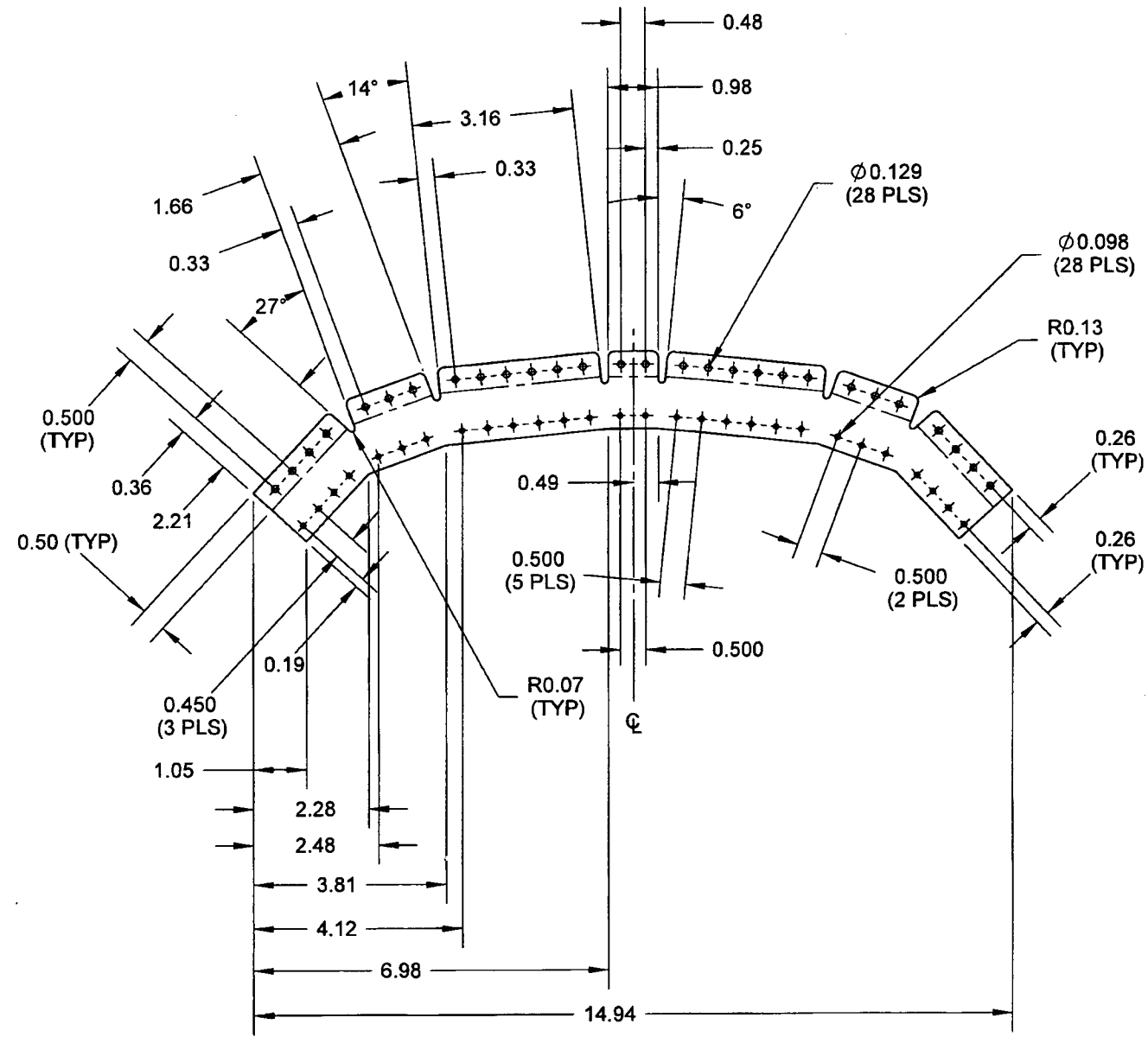


**DETAIL A**

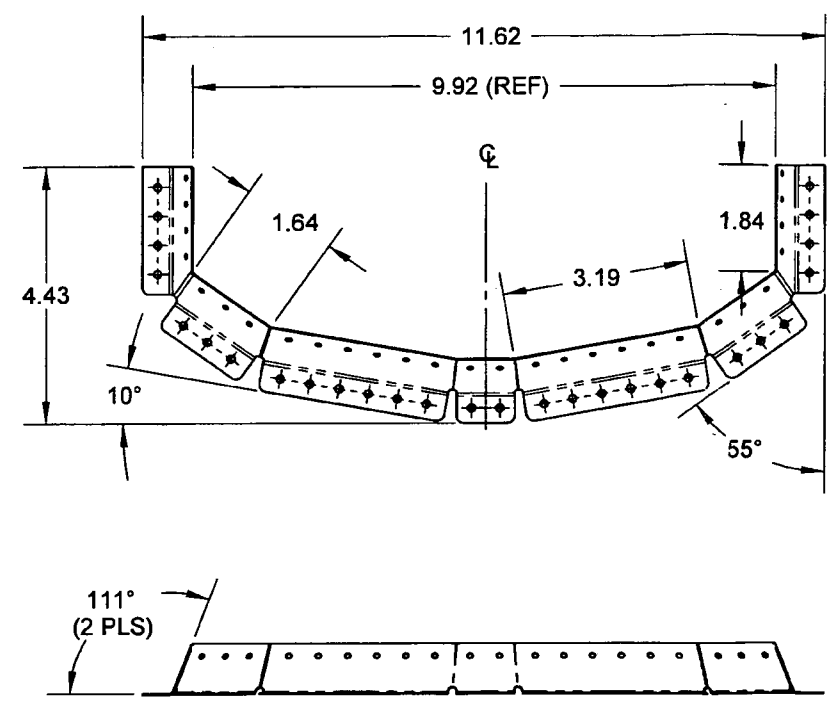
**D3651-3F FLAT PATTERN**

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MFG. APPR.	MA	<b>D3651</b>	SHEET 4 OF 4
APPROVED	MA	TITLE	SCALE
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NO. 42114



**D3651-5F FLAT PATTERN**



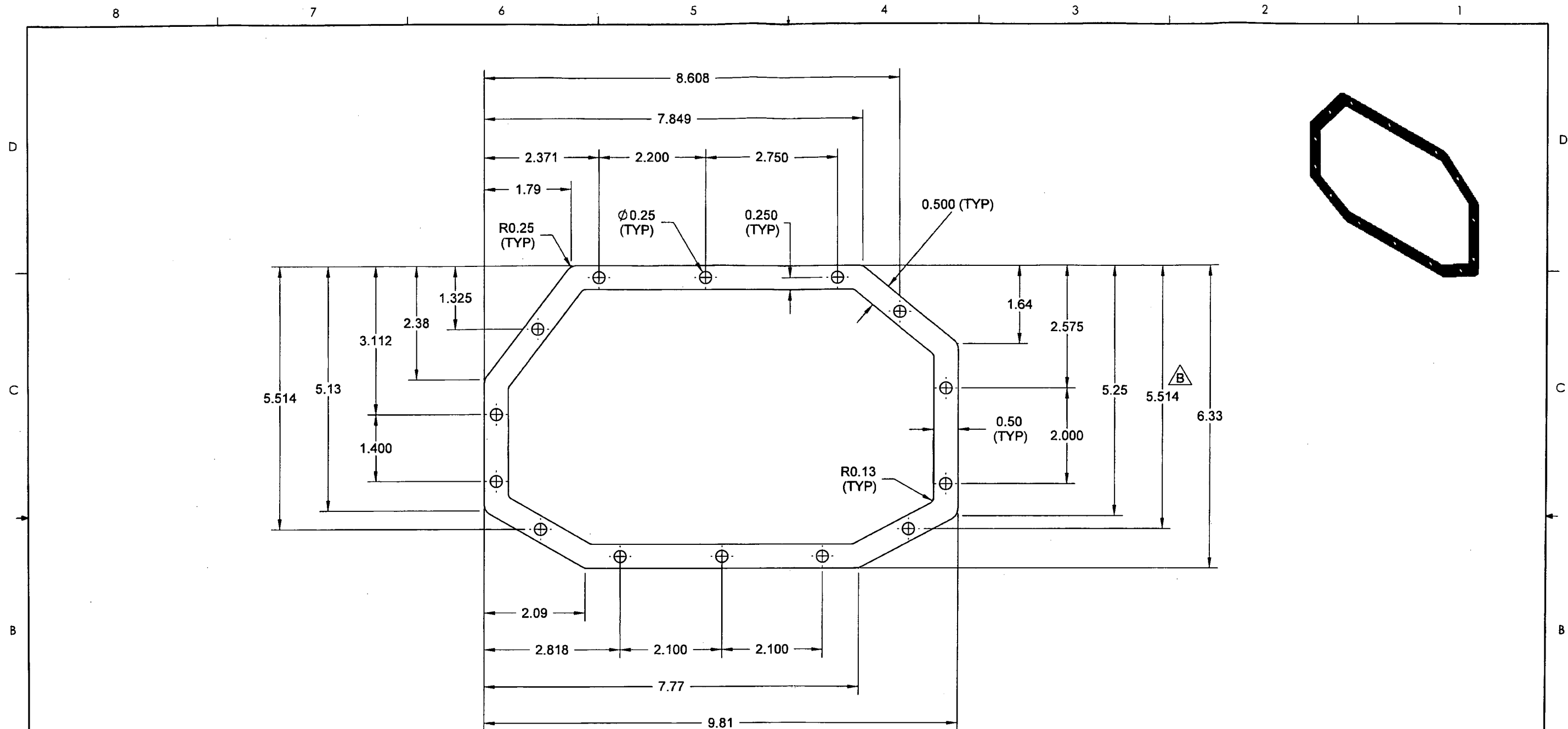
**D3651-5 TOP FLANGE BEND DETAIL**   
(MAKE FROM D3651-5F FLAT PATTERN)

- NOTES:**  
 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: NONE  
 7) WEIGHT: 0.02 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
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MFG. APPR.		D3651	SHEET 5 OF 9
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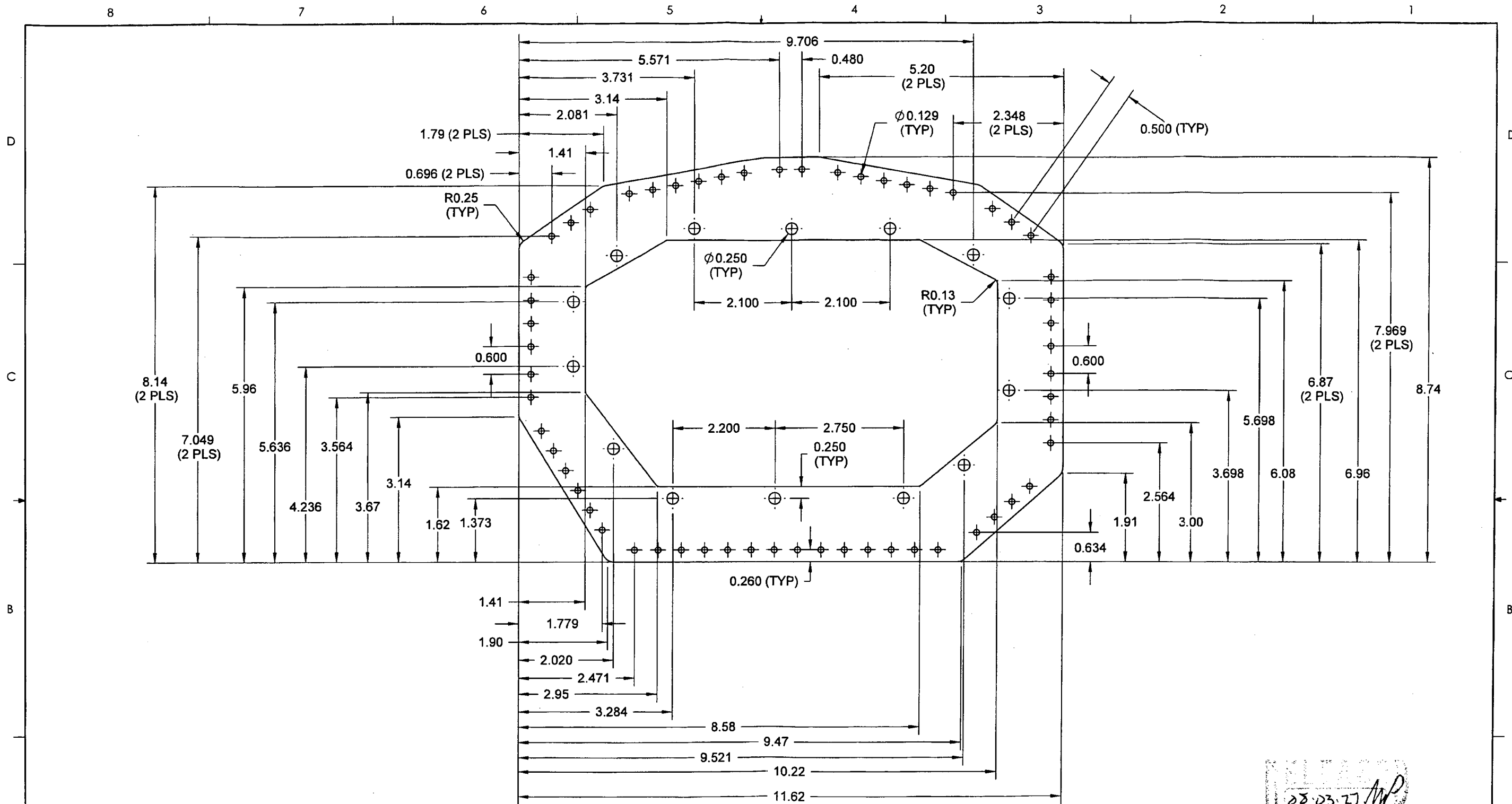
# **D3651-9 INSIDE DOUBLER**

## **NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	MA	D3651	SHEET 7 OF 9
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NO. 42114



# NOTES:

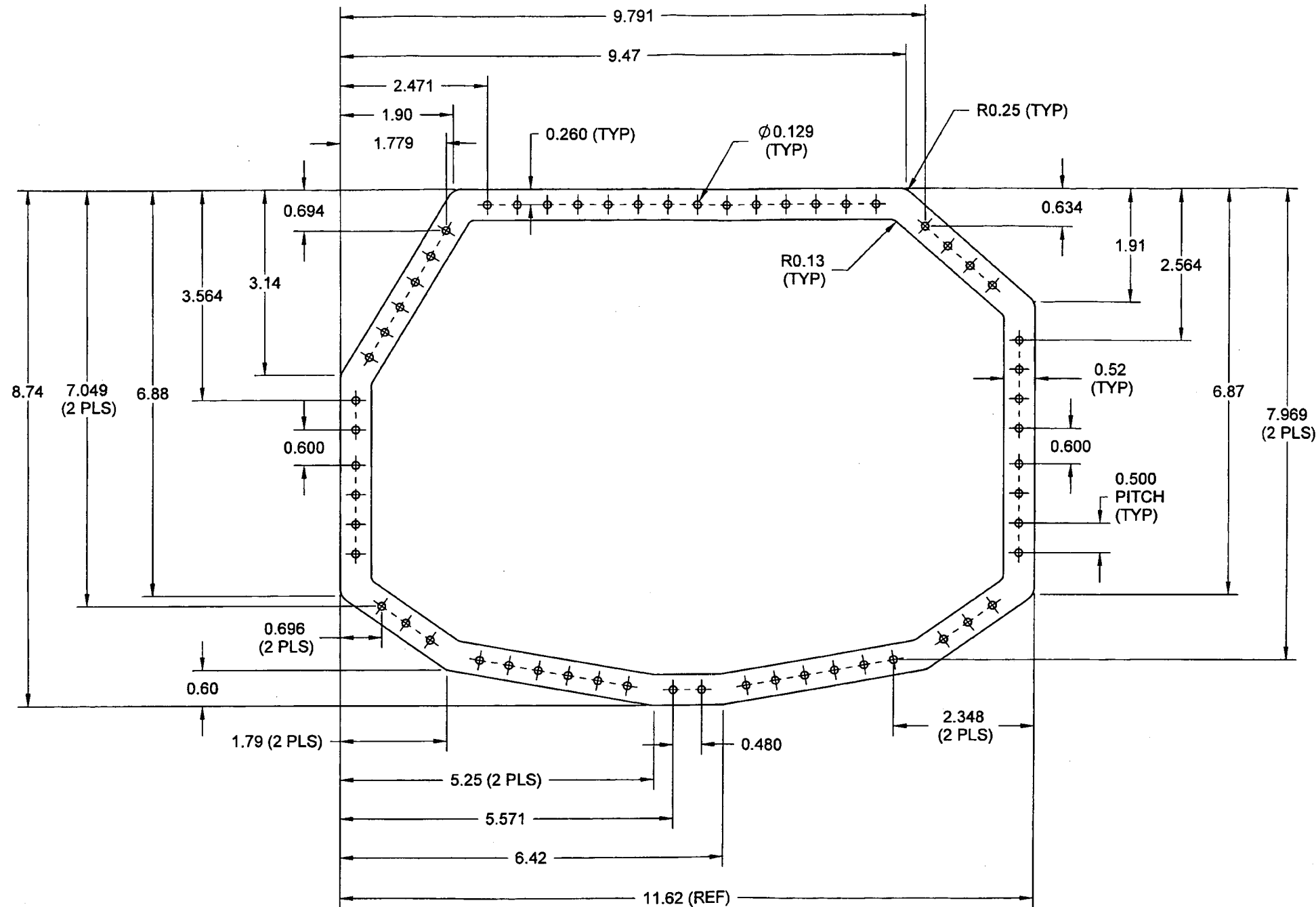
- 1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)  
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.2 lb

**D3651-11 GASKET**



DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
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MFG. APPR.	MA	D3651	SHEET 8 OF 9
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	AFT BASE ASSEMBLY	1:2
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# **D3651-13 OUTSIDE DOUBLER**

## **NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3651	SHEET 9 OF 9
APPROVED		TITLE	
DE APPR.		<b>AFT BASE ASSEMBLY</b>	
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